

Date: Thursday, 8/23/2007 11:53:49 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPRING
Job Number : 34255	
Estimate Number : 11161	
P.O. Number : <u>N/A</u>	Part Number : D32601
This Issue : 8/23/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3260 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NA</u> Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 33678	Material : <u>N/A</u>
Written By : <u>JA</u>	Due Date : 9/15/2007 Qty: 10 Um: Each
Checked & Approved By : <u>9/27/08 23</u>	
Comment : Est. A-04.03.29 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 4454

Make as per Dwg D3260

Possible Supplier: Victory Spring

Material release note is required

C207108124

(10)

2.0	D32601P	Spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spring

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

Ro 7/8/30 (20)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Co 07/08/30 (470)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 79

C207108/31 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 34255

Part Number: D32601

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(22)

Comment: FINAL INSPECTION/W/O RELEASE

27/08/31

Job Completion



U 27/08/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

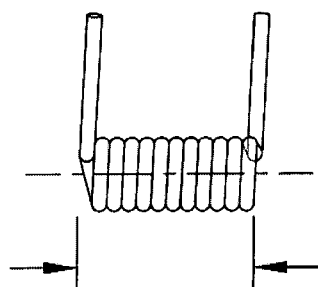
NOTE: Date & initial all entries



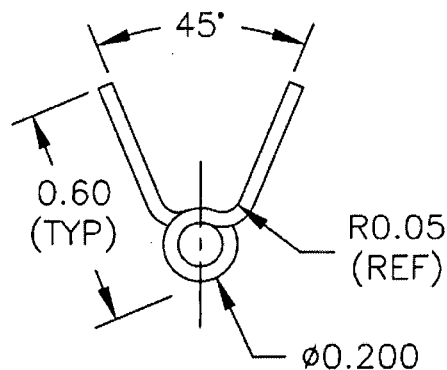
DESIGN RE	DRAWN BY JA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3260	REV. A SHEET 1 OF 1
DATE 04.02.27		TITLE SPRING	SCALE 2:1
A	04.02.27	NEW ISSUE	

RELEASED
04.04.07

SPECIFICATION CONTROL DRAWING



$\phi 0.040$
12 COIL
(REF 0.480)



D3260-1 SPRING

D3260-1 NOTES:

- 1) MATERIAL: AISI 302 SS SPRING WIRE $\phi 0.040$ PER ASTM A313
(MIN TENSILE STRENGTH = 250 ksi)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE.
WORK ORDER
NO. 34255

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REPORT FOR: Dart Aerospace Ltd		DATE: 8/29/2007
PO # 4454	PART/DRAWING #: D3260 Rev A	
SPRING DESCRIPTION: D32601P		QUANTITY: 20

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS 302	yes	
Material diameter	0.040	0.041	
I.D.			
O.D.	0.200	0.1995	
Number of Coils	12 Ref	12.1	
Free Length			
Helix	LHW	LHW	
Legs Angles	45 DEG.	40-50 deg	
Leg Length	0.60 OAL	.585 - .630	

COMMENTS

Mill Certificate attached: yes Material Heat number 45101

INSPECTED & CERTIFIED BY: JEREMY BURROWES

Packing List & Material Certification

68059
Nov 04 2002
REPRINT
Page: 1 Of 1

Victoria Spring Ltd
534 David Street
Victoria
British Columbia
V8T 2C8

Victoria Spring Ltd
534 David Street
Victoria
British Columbia

V8T 2C8

Packing List

11334	U.P.S.	Nov 01 2002
20	24	811-18-0400-01
Stainless Steel T302 Spring .0400		
.040 dia x coil		
25	1 coil	
11/4/02		

All claims for shortages must be made within 10 days.
Goods may not be returned without a Gibbs Authorization Number.
The order will be billed at the price prevailing at the time of shipment.

Material Certification

45101	ASTMA313098
.074	1.29
.022	.003
.63	18.80
8.40	.19
.21	.03
291000 / 298000 PSI	/
/ PSI	/
0.00 / 0.00	

Comments

[Signature]
Quality Department
We certify the above to be a true analysis of the material